

Work Order ID 67737

Tuesday, March 29, 2011 2:29:49 PM



Page 1

Item ID:	D4055-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tank Upper Cut Out					
Start Date:	3/29/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	4/8/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>H</u>	Date:	<u>11-03-30</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4055	A								

100		0.00							
-----	--	------	--	--	--	--	--	--	--

Purchasing	Memo	0.00							

Purchasing	Issue P/O: <u>13750</u>								
	Purchase part as per Dwg D4055								
	Possible Supplier: GFI								
	Material release note required								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--------------------------------------------	------	--	--	--	--	--	--	--

Packaging	Memo	0.00							

Packaging									
-----------	--	--	--	--	--	--	--	--	--

120	QC6- Inspect dimensions to drawing	0.00							
-----	------------------------------------	------	--	--	--	--	--	--	--

QC	Memo	0.00							

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

CZ 11/03/31 (4)

P 11/4/20 (4)

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67737

Page 2

Tuesday, March 29, 2011 2:29:49 PM

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4. BR 11-4-05.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/4/25 SP (4)

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/4/25 SP 4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Upper Cut Out

Start Date: 3/29/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25 JF

ME 11-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 2:29:54 PM

Page 1

Work Order ID: 67737



Parent Item: D4055-5



Parent Item Name: Tank Upper Cut Out



Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-5P  Tank Upper Cut Out		Purchased	No			110	Each	0.0000	1 	4			

Signature (4)

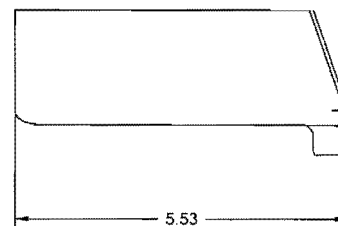
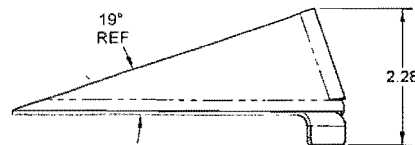
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

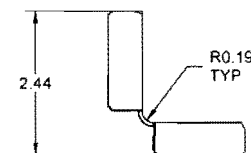
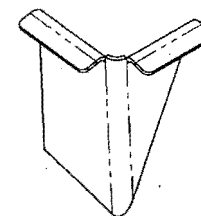
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47737



D4055-5 UPPER CUT OUT

RELEASED
2018-05-05
MD

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

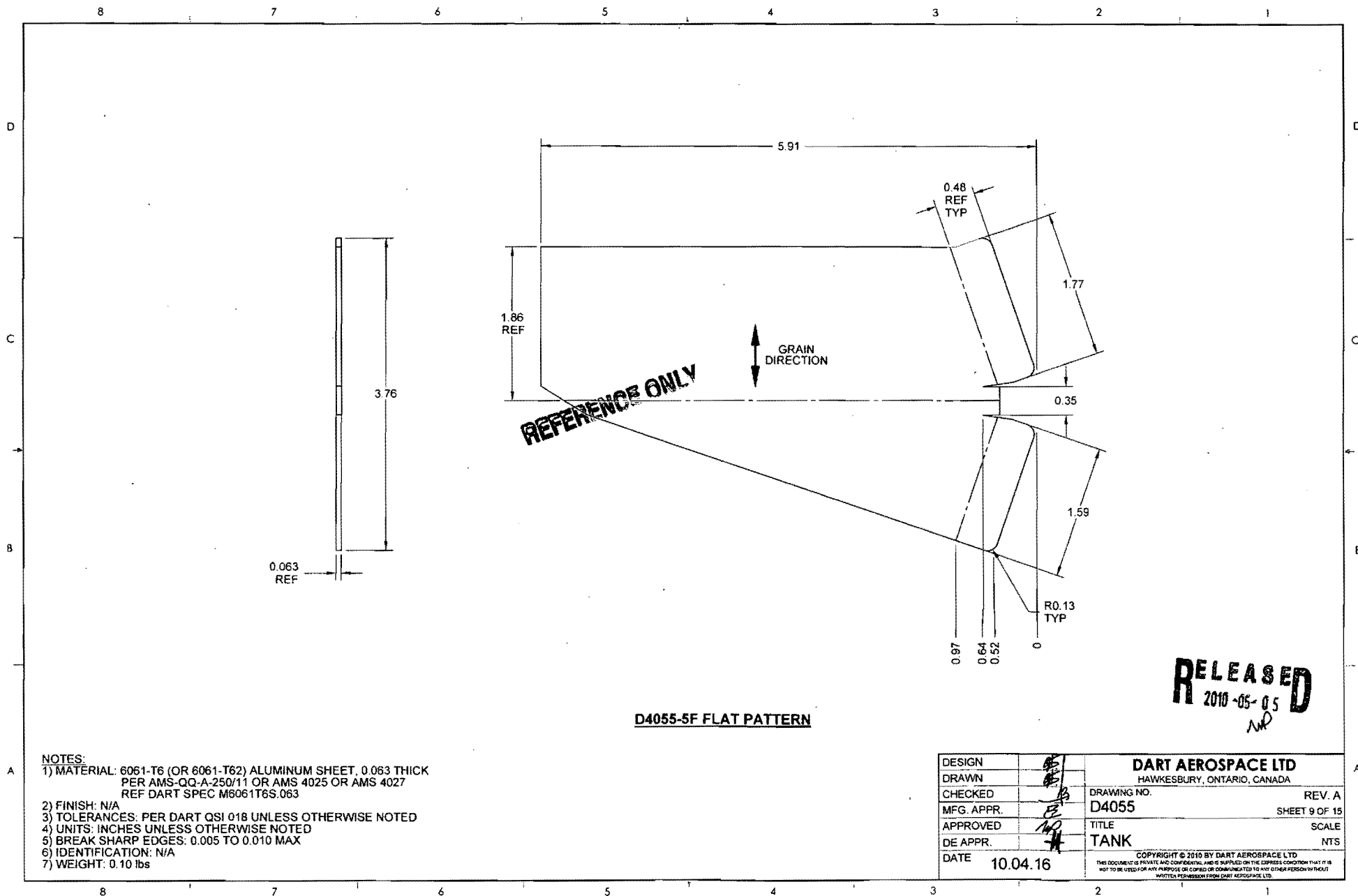
W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4055	SHEET 9 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13750**

Purchase Order Date 3/31/2011

PO Print Date 3/31/2011

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

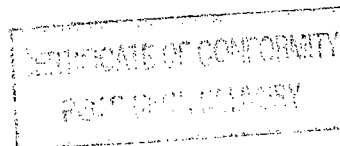
PAID
CD 11/10/31

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4055-5P	Tank Upper Cut Out	4/22/2011 Yes	4.00 Each	FedEx PI collect	\$115.0000	\$460.00

Special Inst: AS PER DWG D4055 REV. A
B67737

PO Total:

\$460.00



Change Nbr: 1

Change Date: 3/31/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE				N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
JR	DY	MO	AN		
18	04	11		0460237	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0229885	PO13750	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
4	D4055-5P	TANK UPPER CUT OUT
<div>8116412</div> <div>MFG. JOB# J0229885 QTY 4</div> <div>8 CONTRÔLE QUALITÉ ISO 9001:2008</div>		CERTIFICATE OF CONFORMANCE REQ

EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

8/11/04/20

CERTIFICATE NO. 4 OUR JOB NO J0229885 SHIPPING MEMO 0460237

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	4 PCS	PO13750	D4055-5P	A	TANK UPPER CUT OUT	A

MATERIAL

.063 THK AL 6061-T6
(AMS-QQ-A-250/11)

SUPPLIED BY

SAMUEL / ALCOA INC

MAT. REL NO.

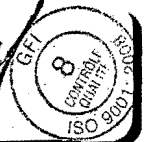
116412

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0229885-001 (4 PCS)		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 18 APRIL 2011

G.F.I. Q.C. REP. *[Signature]*





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: MARCH 08th, 2011

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0078119
Customer's order #:

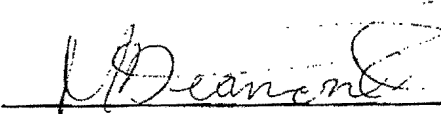

de commande SSMQ: 527480
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	1	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	116412

Bien à vous,
Yours truly,

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

Ship From: RIVERDALE, IA.

1196245	0				
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page
2011-01-03	5528224	00000	1000247864-4		DCE-47864-4
P.O. No./Govt Contract No.	Customer	Alcoa Item			
C63071 Ln#: 1	SAMUEL SON & CO LT G041094947R05				

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URPE H9X 3T5 QC

Item Description
0.063 IN TH (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED, AMS4027 REV N EXC MRK ASTM B209 REV 07 CMMPO25 REV S ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/- 20 % CQR 0210640 REV 05 CUST REQ 10-12-28 *** W/E 11-01-08 ***

Sublot

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	260783	116412	4055	100	PC	27714 46940 07097748
2	260785	116412	938	23	PC	27714 46940 07097749
3	260787	116412	4089	100	PC	27714 46940 07097750
			9082	223		

Notes for CQR: 0210640.5

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0210640.5 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T6	Long Transv.	Max		
		Min	42.0	35.0 10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Lot: 116412	Min	0.40		0.15		0.8	0.04				REMAIN

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T6	Long Transv.	2	49.8	44.2	10.5



CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

1196245	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item Page
2011-01-03	5528224	00000	1000247864-4	DCE-47864-4 2
P.O. No./Govt Contract No.	Customer	Alcoa Item		
C63071 Ln#: 1	SAMUEL SON & CO LT G041094947R05			

Lot: 116412 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
50 44.4 10.4

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
10R03563	Actuals	0.63	0.5	0.28	0.06	1.0	0.18	0.01	0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



